

Date: Friday, 9/1/2006 12:16:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28400
 Estimate Number : 10512
 P.O. Number : *N/A*
 This Issue : 9/1/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 28251
 Written By : _____
 Checked & Approved By : *[Signature]* 06 09.01
 Comment : Est: A 02.04.15 New Issue NG
 Est: B 05.12.12 added deburr EC

Drawing Name : PLUG
 Part Number : D26511
 Drawing Number : D2651 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 9/25/2006

Qty: *300* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0421 f(s)/Unit Total : 12.6315 f(s)
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)
 Batch: *m101421*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Issue P.O. 2057



0609/06
300

Comment: HAAS CNC VERTICAL MACHINING #1
 1- Turn as per Folio FA219 and Dwg D2651 *turn per dwg D2651 Rev B*
 2- Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive + Inspect



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

for transit damage 06/09/06 300

4.0 QC3 SECOND CHECK



Comment: SECOND CHECK

Inspect level 5 *02-09-18*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr as per dwg D2651

N/A 0609/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PR Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M. 06-09-19

(300)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

FC 06 09 20 (304)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

A.M. 06-09-20

(304)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FPIS*

FC 06 09 20 (304)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Pa 109 20

Job Completion



u doc. 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

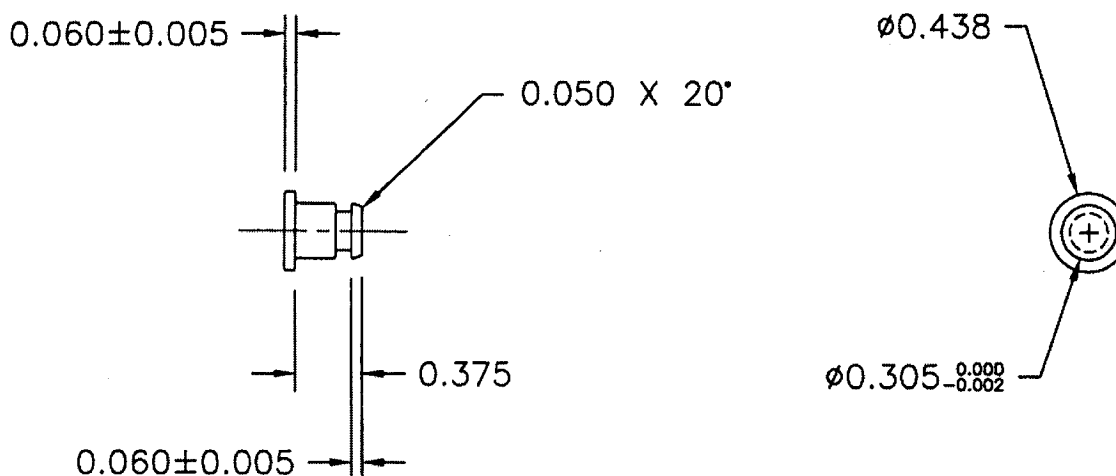


DESIGN A	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2651	REV. 8 SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

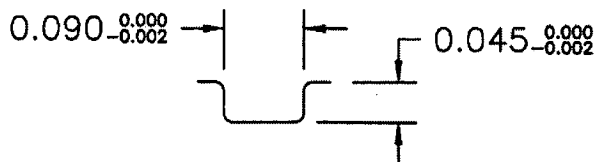
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28400

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

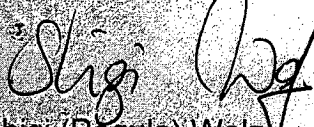
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>MATERIAL BATCH NUMBER</u>	<u>P.O. NUMBER</u>
358	D2649	Cross Bolt Spacer	M100704	Linda
155	D2649	Cross Bolt Spacer	M19051	Linda
606	D2651-1	Plug	M101421	Linda
200	D2743	Cross Bolt Spacer	M100451	Linda

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, September 15, 2006

